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RBE350A94-3700-B
Job Sheet 181867



Part No: RBE350A94-3700-B

Job Qty: 1 ea

Part Name: Swashplate Immobilizing Tool, Short Brace Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 8/10/18

Job Tracking No:

Due Date: 8/23/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE350A94-3700-B Rev. 6 IPP Rev. A 18.08.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/23/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		8/23/18	0.00	0.10	Small Fab-3		
120	QC	1 pcs		8/23/18	0.00	0.00	QC5		
130	Packaging	1 pcs		8/23/18	0.00	0.00	Packaging3-1		
140	QC21-FG	1 Ea		8/23/18	0.00	0.00	QC21		

Part Op
Descriptions: 110 - 1-Pick bag and tag.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE350A94-3700-B-1A	Short Brace Assembly	3 Ea (3 ea)	90-Start up Operation	5109250

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBE350A94-3700-B-1A	3	0	0

181868

Part Specifications

Specifications could not be found.



Container No: S109422



Part: RBE350A94-3700-B

Job No: 181867

Serial No/Batch: S109422

Revision: 6

Inspector:

Exp Date:

Instructions:

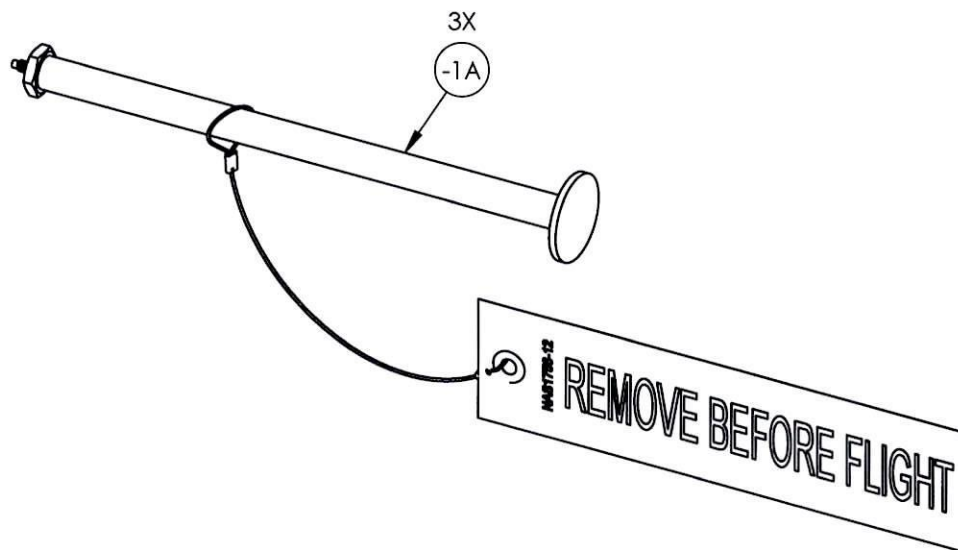
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Plex 8/10/18 10:36 AM dart.logan.david

Date: 09/12/18

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		BROKE OUT FROM KIT AS INDIVIDUAL TOOL.	8/21/2012	RJC	RW
5		CH'D T/N WAS RBEA94-3700-B IS RBE350A94-3700-B. -01 CH'D DIM WAS Ø.75 IS (Ø.75), WAS .083 IS (.083). -03 CH'D DIM WAS Ø.570 ∇ .079 IS Ø.570. ADDED DIM Ø.586 P.F. -01. (Ø.20). -05 CH'D DIM WAS Ø2.00 IS (Ø2.00). WAS Ø.586 P.F. -05 IS Ø.586 P.F. -01. CH'D TOLERANCE ON NON-CRITICAL PARTS.	5/23/2014	DPD	RJC
6	16-0151	UPDATED TO NEW DRAFTING STANDARD. DELETED P/N B, ADDED P/N'S -1A. -09. -011. -013. CH'D -07 DESCRIPTION WAS SOCKET HEAD SET SCREW DOG POINT IS SOCKET HEAD SET SCREW EXTENDED POINT. -1A ADDED DRAWING. -01. -03. -05 ADDED FINISH SPEC QSMI-6.2.2. B.O. REV D. -01 CH'D DIM WAS (Ø.75) IS Ø.75. WAS (.083) IS .08. ADDED DIMS Ø.6047/.6040 (P.F. -03). Ø.6047/.6040 (P.F. -05). .88. .88. 2X .03 X 45°. ADDED ENGRAVE NOTE. -03 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01). -05 CH'D DIM WAS Ø.586 P.F. -01 IS Ø.6056/.6052 (P.F. -01). WAS (Ø2.00) IS 2.00. CH'D MATERIAL WAS 1018 IS 1018/1020 CR.	2/24/2017	RJC	SM



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
	X		-1A	3	SHORT BRACE ASSEMBLY			2
	1		-01		TUBE	STEEL		3
	1		-03		CAP	SP HEX		4
	1		-05		FOOT	1018/1020 CR		5
	1	B/O	-07		SOCKET HEAD SET SCREW, EXTENDED POINT	STEEL	M6 X 1 X 30mm (MCMaster-CARR #92905A225)	2
	1	B/O	-09		REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	2
	1	B/O	-011		LANYARD CABLE	COATED STEEL	Ø1/16 X 8 (CARR LANE #CL-2-C)	2
	2	B/O	-013		FERRULE	ALUMINUM	Ø1/16 X 3/8 (MCMaster-CARR #3896T31)	2
	ASSY -1A							

DART AEROSPACE																											
TITLE SWASHPLATE IMMOBILIZING TOOL SHORT BRACE ASSEMBLY																											
DWG NO. RBE350A94-3700-B	REV 6																										
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED</td> </tr> <tr> <td>HEAT TREAT</td> <td>DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FINISH</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>SPEC</td> <td>.XX ± .01 ANGLES ± .5°</td> </tr> <tr> <td></td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td>DRAWN BY: CLOUGH</td> <td>1. BREAK ALL SHARP EDGES</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>.015 x 45° OR .015R</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>2. DIMENSIONAL LIMITS APPLY</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>AFTER PLATING</td> </tr> <tr> <td>APPROVED: MACKOVJAK</td> <td>3. INTERPRET DIM AND TOL PER</td> </tr> <tr> <td></td> <td>ASME Y14.5M-2009</td> </tr> <tr> <td></td> <td>USED ON MODEL</td> </tr> <tr> <td></td> <td>EUROCOPTER AS350/355</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED	HEAT TREAT	DIMENSIONS ARE IN INCHES	FINISH	.XXX ± .005 FRACTIONS ± 1/8	SPEC	.XX ± .01 ANGLES ± .5°		.X ± .1 SURFACES = 125/	DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES	CHECKED: DUERFELDT	.015 x 45° OR .015R	OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY	QA APPR: LINDSAY	AFTER PLATING	APPROVED: MACKOVJAK	3. INTERPRET DIM AND TOL PER		ASME Y14.5M-2009		USED ON MODEL		EUROCOPTER AS350/355
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SCALE 1:4	DATE 8/21/2012 SHEET 1 OF 5																										